

Work Order ID 135186

Wednesday, September 16, 2015 1:01:44 PM

135186

Page 1

Item ID: D4704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly
 Start Date: 7/31/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/3/2015 Req'd Qty: 1.00 ***1*** Customer: CNORT28
 Reference: RMA RA112079

Approvals: Process Plan: UMF Date: 8-9-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4704	A								
100		0.00							DAS 38 9-09
100									
QC	Memo	0.00							
Quality Control	INSPECT RA112079 D4704-041 X 1 B127247								SEP 17 2015
	PARTS IS USED GIVE TO ENG FOR EVALUATION								
	SAD 15/09/17								
110	QC21- Final Inspection - Work Order Release	0.00							
110									
QC	Memo	0.00							
Quality Control									

20150921 **SAD**
~~**20150917**~~
12150917

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

Wednesday, September 16, 2015 1:01:43 PM

Page 1

Work Order ID: 135186

135186

Parent Item: D4704-041

D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 7/31/2015

Required Date: 8/3/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS
12.10.16 AS PER DWG REV.A DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041		Manufactured	No				Each	2.0000		1			

D4704-041

Expandable Pin Assembly

Location

Loc Qty

Loc Code

ST123

2

134482

2

1x127247 MF
15-9-16

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
				OTHER : ☐			

RA 112079 D4704-041

B127247

Received @ Dart June 16th, 2015
Inspected@ Dart July 31st, 2015

CUSTOMER: NORTH MEMORIAL MEDICAL
CENTER
CUSTOMER CONTACT: GINNY TRIPLETT
SHIPPED FROM: CRYSTAL MINNESOTA, USA

Instructions for RA 112079 D4704-041 B127247

- Parts have been used
- Need work order to give to Engineering for evaluation

Time Estimate: 1 hour

Departments Required: QC & Engineering

Pictures Attached: N/A

QTY INSPECTED: .x1 D4704-041 B127247

**THIS INSTRUCTION SHEET
MUST BE ATTACHED TO THE
RESTOCKING WORK ORDER
AT ALL TIMES!!!!**

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WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐			